

Work Order ID 57336

April 5, 2010 3:02:56 PM



Page 1

Item ID: D2873-045

Accept



Setup Start



Revision ID:

Item Name: Nut Plate Assembly

Stop



Start Date: 05/04/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 19/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

RL

Date: 10-4-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 2.700" long

2L 10/04/05

19 *0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-5
Dwg Rev *A* F1819Folio Rev *AA*

2L 10/04/06

19 *0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

2L 10/04/06

19 *0*

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 19/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	MNE 10/04/06			19	0		
140 Small Fab Small Fab Small Fab	Small Fab Memo 1-Deburr □2- C'sink as per Dwg D2873	0.00 0.00				9510/04/13 (19X)			
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 10/04/13						
						(counter) 49			

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Setup Start



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Stop



Start Date: 05/04/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 19/04/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



HandFinish

Memo

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

10-4-13

19

170



QC

Memo

Quality Control

QC3- Inspect Part Finish

0.00

10-4-14

X19

0

180



Small Fab

Memo

Small Fab

Small Fab

0.00

0.00

1-Assemble as per Dwg D2873 ☐ 2-Identify as D2873-045

10/04/14 19

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 57336

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Item ID:	D2873-045	Accept		Setup	Start	
Revision ID:						
Item Name:	Nut Plate Assembly				Stop	
Start Date:	05/04/2010	Start Qty:	20.00			
Required Date:	19/04/2010	Req'd Qty:	20.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8/06/14			(X)19 counts			
200 Packaging Packaging	Identify as per dwg & Stock Location: X-tube RSSY Memo	0.00 0.00				ml	10	04	26 (19)
210 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/04/27 J

W count 27

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

April 5, 2010 3:03:00 PM

Page 1

Work Order ID: 57336

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly

Comments: IPP A 05.09.13 New issue KJ/JLM

Start Date: 05/04/2010

Required Date: 19/04/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21075L5		Purchased	No			100	Each	131.0000	40.0000			
-----------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



Nut Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST303

131

112243

131

M6061T6B0.375X01.00

Purchased

No

180

f

3.6000

4.7368

0



6061T6 BAR .375 x 1.00

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT01

3.6

113325

3.6

MS20426AD4-6

Purchased

No

180

Each

3,719.000

80.0000



Rivet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST317

3719

110139

3719

Handwritten signature and date: 5/10/04/14

38

M110829

3.15

Handwritten: SL 10/04/05

Handwritten signature and date: 5/10/04/14

78

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	57336
Description: Radius Block		Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	✓			
1.000	+/-0.010	1.000	✓			
0.750	+/-0.010	.750	✓			
0.250	+/-0.010	.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
Ø0.128	+0.005/-0.001	Ø.129	✓			
0.359	+/-0.010	.360	✓			
Ø0.316	+0.006/-0.001	Ø.318	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.250	✓			
0.061	+/-0.010	.062	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.230 x .125	✓			

Measured by:	<i>[Signature]</i>
Date:	10/04/06

Audited by:	<i>[Signature]</i>
Date:	10/04/06

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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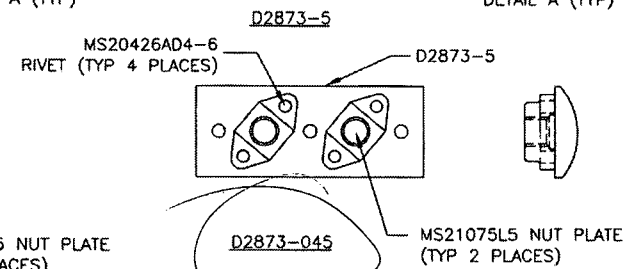
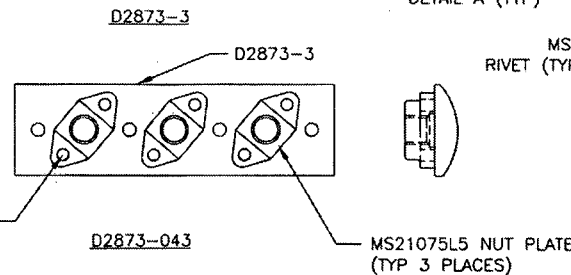
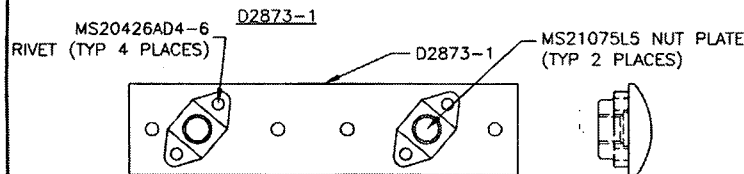
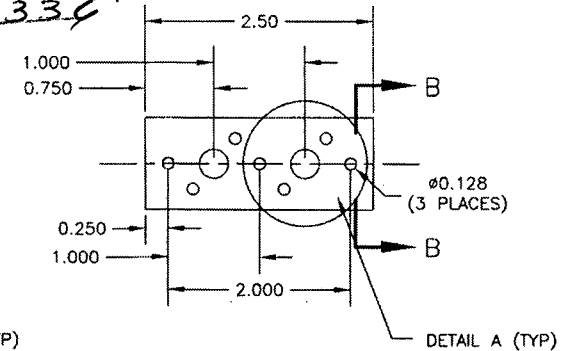
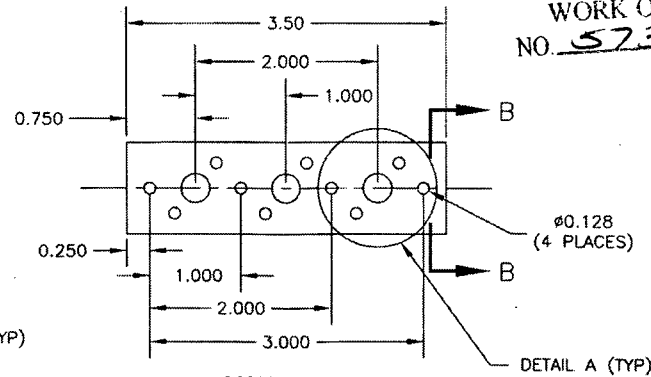
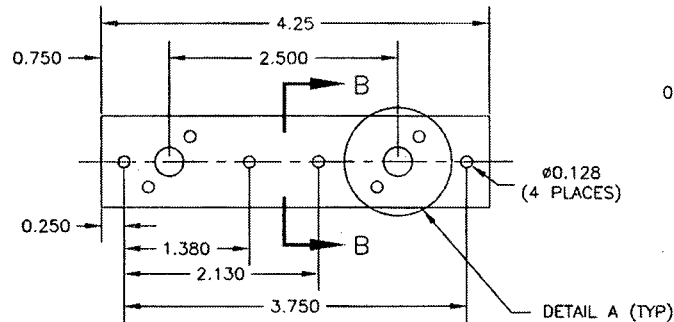
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 57336

10-4-05



D2873-041

MS20426AD4-6
RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE
(TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE
(TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

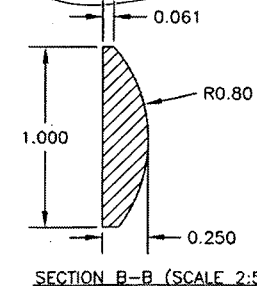
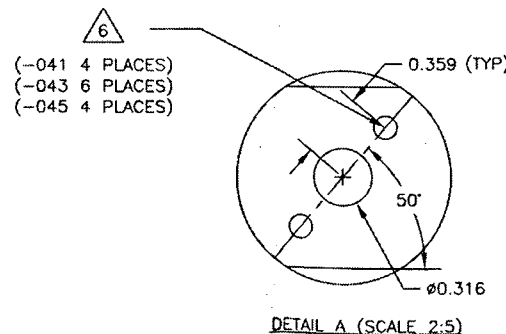
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD WARRICKSLEY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

W/O:		WORK ORDER CHANGES						
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